

CREATE CHANGE

Maestro CAM Final Checking and Saving

If you are unsure of anything, please don't hesitate to ask UQ Innovate Staff.

Once you have finished with Maestro CAM parts 1-5 and you" tab.

It is important to check all your tool-pathing before saving your project.

Drilling should come first in order of tool-pathing priority, then routing, then pocket forming and last of all Perimeter Routing.

Check the "machining" list to for correct ordering, if it isn't you can either delete and reapply in the correct position or move with "arrows".





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The final instruction you will want to add will be a request to "Parking" the machine. This will be found on the "Machines" tab. Make sure you have the last command in the list highlighted before clicking. For an end Park you can use default "No stop", just click "Apply".



These can also be placed in other positions with "Stop", "Wait for start" this is useful after drilling if screw fixturing is required.



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Have all "Boring" geometries been applied, and are the diameters and depths, correct?



Have "Routing" operations been applied and correctly compensated? Are diameters and depths, correct?





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Have all "Pocket forming" operations been applied correctly, overlap allowing for material hardness?

Remember, do not attempt to use helicoidal or multiple passes they are broken.





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Have you checked your "Perimeter routings" for the following problems?

Is your geometry internal or external and does the toolpath match? This may cause wasted material. Has there been perimeter cutting applied to open geometry? This will break cutters. Is there enough space between parts or do tool-paths cross each other or leads? This will compromise outcomes. Is there enough room for the tool size in your geometry? This will cause unwanted leads. Tool Ø+1mm is the rule for spacing in your geometry.





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Check that the tooling you have assigned is loaded in the machine by checking the white board at terminal.

| Pos | Code | No. | 512e 2011111 | Keacii | Max Cut | Description | materials | Spill Board Thickness |
|-----|-------|--------|--------------|--------|---------|-------------|-------------------|-----------------------------------|
| 1 | E099 | 100191 | V | 5.0 | 1.000 | Drag Knile | Ripperley | the second second |
| 2 | E002 | 1002 | 80.0 | 12.0 | 2.0mm | Face Mill | Wood\Foam | 12.0 |
| 3 | E003 | 1003 | 18.0 | 68.0 | 10.0mm | End Mill | Wood\Foam | 13 9 |
| 4 | E004 | 1004 | 12.0 | 78.0 | 10.0mm | Up Cut | Wood\Foam | |
| 5 | E005 | 1005 | 8.0 | 40.0 | 10.0mm | Roughing | AII\NF | Current BZ |
| 6 | E006 | 1006 | 8.0 | 30,0 | 5.0mm | Up Cut SF | NF\Plastic | |
| 7 | E007 | 1007 | 3.0 | 12.5 | 2.0mm | Up Cut SF | NF\Plastic | 12.0 |
| 8 | Sorti | 1051 | 1.5 | n | 12. | Unit | Plasti | 15.0 |
| 9 | E055 | 1055 | 5.0 | 80.0 | 80.0mm | Drill | AII\NF | the second second |
| 10 | E010 | 1010 | 8.0 | 35.0 | 10.0mm | Finishing | Wood\Foam | |
| 11 | E011 | 1011 | 26.0 | 13.0 | 5.0mm | 45° Mitre | AII\NF | Key Pin: 013145 |
| 12 | Eoui | 1001 | 12.0 | 80.0 | 10-0mm | Ball Nose | Nood form | NF=Non-ferrous SF=Single Flute |



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Before saving you may wish to change the work "Area" found under "Machine parameters" in the Machines tab.



EF for half table or EH for full table.

| 🐻 Machine parameters | - <u> </u> |
|--|----------------------|
| Area | EF |
| Repetitions | 1 |
| Enable execution at continuous cycle | |
| Maintain the program machining sequence | |
| \checkmark Multiple borings can alter the program made | chining sequence |
| Mechanical options | 18808832 |
| \odot Blocking (default: \Box) | 10 |
| Enable technological compatibility on spec | ular areas in X or Y |
| | |
| Automatic optimisation in program executi | on |
| Automatic optimisation in program executi | Apply Cancel |



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Once you are satisfied there are no apparent problems. Click the drop box under save from the home tab and click "Save as project"



You will then be prompted to name your file make sure you save this onto a USB drive. You should now be ready to run the program.

| Save As | | | | | | | × |
|--|---------------------|---------------------|-------------|------|--------|-------|---|
| (c) \Rightarrow = \uparrow \bigcirc UQJSTAFI (E) \Rightarrow CNC Documentation \checkmark \bigcirc Search CNC Documentation. | | | | | | | |
| Organize - New folde | | II • | | 0 | | | |
| Desktop ^ | Name | Date modified | Туре | Size | | | |
| Documents | BoringDrilling | 26/03/2024 10:15 AM | File folder | | | | |
| Downloads | Checkingand Saving | 28/03/2024 9:30 AM | File folder | | | | |
| Music | DragKnifeCutting | 13/03/2024 2:22 PM | File folder | | | | |
| Pictures | ImportDXF | 26/03/2024 8:47 AM | File folder | | | | |
| Videos | Maintenance | 15/03/2024 2:34 PM | File folder | | | | |
| Lecal Dick (C) | Otherstuff | 15/03/2024 12:25 PM | File folder | | | | |
| LOCALDISK (C:) | PerimeterRouting | 26/03/2024 11:59 AM | File folder | | | | |
| DAIA (D:) | PocketForming | 26/03/2024 11:19 AM | File folder | | | | |
| UQJSTAF1 (E:) | RoutingOperations | 26/03/2024 10:55 AM | File folder | | | | |
| 🛫 Groups (G:) | Tooling | 12/02/2024 2:29 PM | File folder | | | | |
| Home (H:) | Training Doc | 15/03/2024 11:40 AM | File folder | | | | |
| 🛖 Material (M:) | Name your file.pgmx | 27/03/2024 3:27 PM | PGMX File | | 954 KB | | |
| × | | | | | | | |
| File name: Name | your file.pgmx | | | | | | ~ |
| Save as type: Project | (*.pgmx) | | | | | | ~ |
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| Hide Folders | | | | | Save | Cance | |
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